



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2282-7
Job Sheet 172490



Part No: D2282-7

Job Qty: 60 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		3/3/18	0.00	0.00	Start Up Machining		JB 18-03-01
100	Hardinge	60 pcs		3/5/18	0.02	1.57	Hardinge		JB 18-03-01
120	QC	60 pcs		3/5/18	0.00	0.00	QC8		JB 18/03/05
130	Packaging	60 pcs		3/5/18	0.00	0.00	Packaging3		DYC 18/03/05
140	QC21-SA	60 Ea		3/5/18	0.00	0.00	QC21		MAD 15 2018

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA190

Descriptions: 130 - ***STOCK IN LARGE FAB***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304P0.675W.091	304/316 Pipe .675 OD x .091 Wall Thickness	3.9960 ft (.0666 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304P0.675W.091	4	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	0.795Inches ± 0.010	0.805 0.785		
2	Handle Tube	0.493Inches ± 0.010	0.503 0.483		
3	Handle Tube	0.675Inches ± 0.010	0.685 0.665		

Plex 2/20/18 9:00 AM Dart.lajeunesse.marie



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Container No: S046990



Part: D2282-7

Job No: 172490

Serial No/Batch: S046990

Revision:

Inspector:

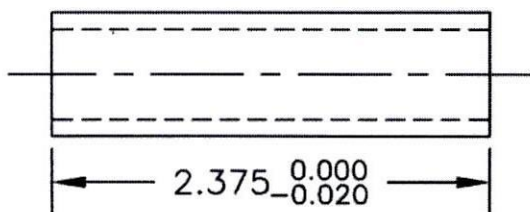
Date: 03/01/18



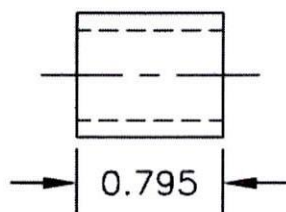
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]
05/09/16

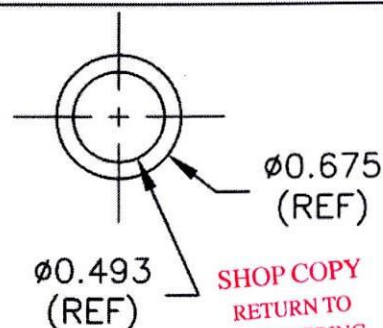
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D2282-3



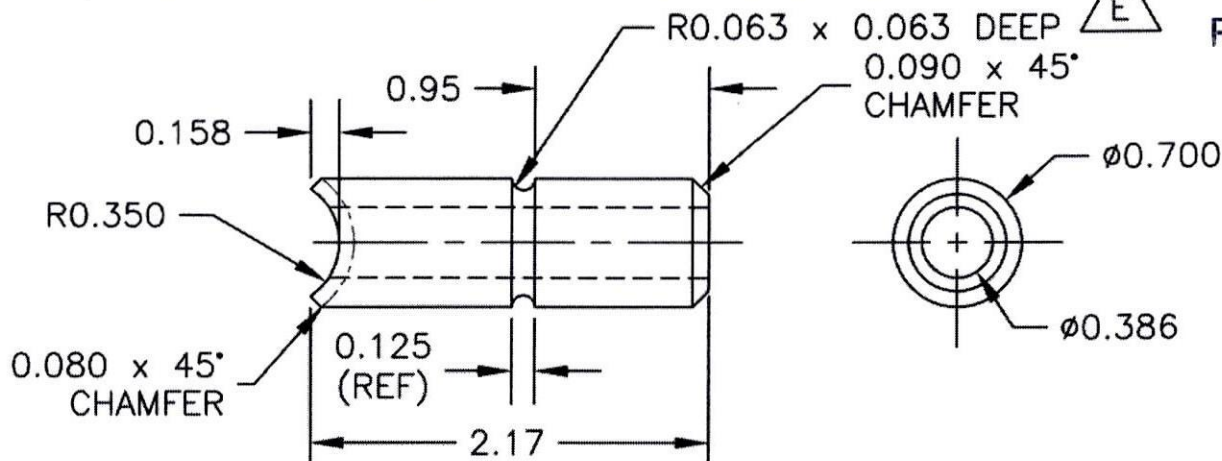
D2282-7



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172490

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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DRAWING NO. D2282	TITLE HANDLE TUBES	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2282-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>M Lee</i>	MFG. APPR. <i>DP</i>	APPROVED <i>all</i>		DE APPR. <i>N/A on</i>		
DATE 17.02.24	DATE 17.06.22	DATE 17-6-22	DATE 2017.06.23		DATE N/A on		

PURPOSE

CORRECT MATERIAL CALL-OUT TO ELIMINATE PIPE/TUBE CONFUSION (NCR16-5830)

CHANGE

MATERIAL CALL-OUT FOR D2282-3/-7 ON SHEET 1 IS UPDATED AS FOLLOWS:

IS:

D2282-3/-7 TUBE:

1) MATERIAL: Ø0.675 X 0.091 WALL SEAMLESS ROUND TUBING, TP304/TP316 STAINLESS STEEL PER ASTM A213 / A269 OR ASME SA213 / SA269
(REF. DART SPEC. M304TR0.675W0.091)
OR
3/8 SCHEDULE 40 SEAMLESS PIPE, TP304/TP316 STAINLESS STEEL PER ASTM A312 OR ASME SA312
(REF. DART SPEC. M304P0.675W0.091)

WAS:

D2282-3/-7 TUBE:

1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W0.091)

RELEASED

2017 JUN 26 *qp*
ECN 17-595

INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	